

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023528**Date Inspected:** 07-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. Liu Huajie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

Trial Assembly:-

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3011K-167(13BE Edge beam to floor beam weld, BK Side,PP122.5 ), and Welder is identified as 051359; ZPMC Quality Control (QC) is identified as Mr. Lvli Qing, The welding variables appeared to comply with the Applicable WPS-B-P-2213-TC-U4b-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3013A-001-038(13BE Deck panel Diaphragm to flange weld, BK Side,PP121.5 ), and Welder is identified as 044760; ZPMC Quality Control (QC) is identified as Mr. Lvli Qing, The welding variables appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3009C-272(13BE Side panel I Rib to Floor beam weld, PP122 ), and Welding Repair Report(WR)B-WR20749,Welder is identified as 066258; ZPMC Quality Control (QC) is identified as Mr. Lvli Qing, The welding variables appeared to comply with the Applicable WPS-345-SMAW-3G(3F)-FCM-Repair-1.

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## WELDING INSPECTION REPORT

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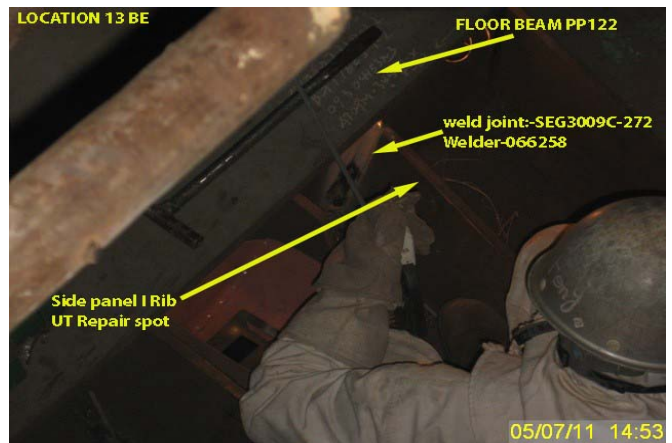
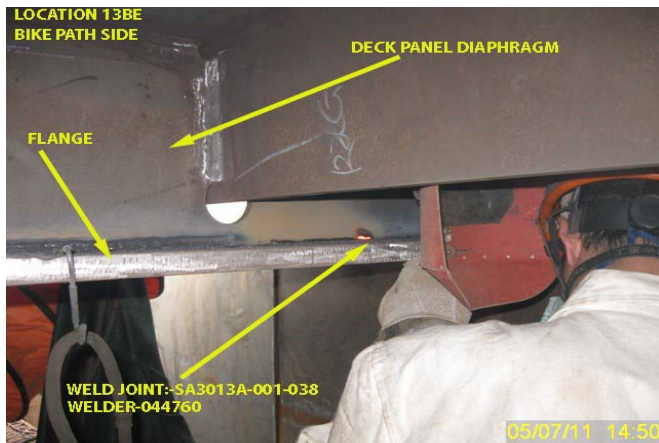
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Shielded Metal Arc (SMAW) welding of Weld Joint SEG3007V-406(13AE Floor beam I Rib weld, CB Side), and Welder is identified as 066416; ZPMC Quality Control (QC) is identified as Mr. Liu Huajie, The welding variables appeared to comply with the Applicable WPS-B-P-2212-TC-U4b-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3009S-084(13BE Bottom panel to Edge beam weld, BK Side, PP122 ), and Welder is identified as 068924; ZPMC Quality Control (QC) is identified as Mr. Lvli Qing, The welding variables appeared to comply with the Applicable WPS-B-P-2112-FCM-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3007R-163(13AE Bottom Panel I Rib to Floor beam weld, PP117.5 ), and Welder is identified as 037743; ZPMC Quality Control (QC) is identified as Mr. Liu Huajie, The welding variables appeared to comply with the Applicable WPS-B-P-2213-TC-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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**Inspected By:** Tharikoppada,Reddy

Quality Assurance Inspector

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**Reviewed By:** Miller,Mark

QA Reviewer